

20

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20772
<b>Description:</b> Spring	<b>Part Number:</b>	D3260-1
<b>Dwg:</b> D3260 Rev. A	<b>Qty:</b>	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	04.04.28	20
2	PG	Issue P/O: 2006389 Make as per Dwg D3260 Possible Supplier: Victory Spring <b>Material release note is required</b>	LL	04.05.03	20
3	RG	Receive and Inspect for transit damage <b>Ensure material release note is attached</b>	CSP	04/05/21	20
4	QC6	Inspect dimensions as per Dwg D3260	AB	04.05.25	20
5	ST	Identify and Stock	CSP	04/05/25	20
6	AC	Cost / part 8.73	JVC	04-05-28	20
7	DC	Close W/O 8.73 Inspect Level 21	JA	04.05.26	20

Rev	Date	Change	Revised By	Approved
A	04.03.29	New issue	KJ/RF EF	JA

**RELEASED**  
04.03.31

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

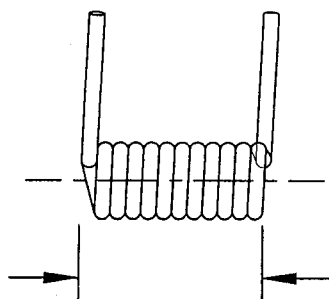
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



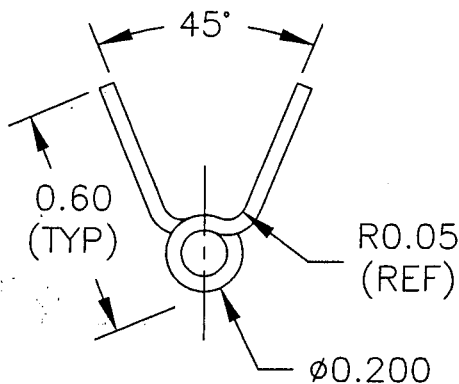
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3260	REV. A SHEET 1 OF 1
DATE 04.02.27		TITLE SPRING	SCALE 2:1
A	04.02.27	NEW ISSUE	

RELEASED  
04.04.07

## SPECIFICATION CONTROL DRAWING



$\phi 0.040$   
12 COIL  
(REF 0.480)



**D3260-1 SPRING**

**SHOP COPY**  
RETURN TO  
ENGINEERING  
**UNCONTROLLED COPY**  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
**WORK ORDER**  
NO. 20772

**D3260-1 NOTES:**

- 1) MATERIAL: AISI 302 SS SPRING WIRE  $\phi 0.040$  PER ASTM A313  
(MIN TENSILE STRENGTH = 250 ksi)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 27, 2004  
03:08 pm

Work Order No : 0020772  
Project Name : D3260-1  
Project For : WK420  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3260-1  
Description : Spring  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 04-27-04  
Est Finish Date : 05-06-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



Wire & Steel Company  
of Canada, Ltd

241 DEERHURST DRIVE, BRAMPTON, ONTARIO L6T 5K3  
TEL: (905) 791-6811 / 1-800-387-2441 FAX: (905) 791-9588  
SLITTING, OSCILLATING, EDGING AND CUSTOM PROCESSING  
INDUSTRY'S CHOICE FOR QUALITY



# Packing List & Material Certification

Gibbs W.O.#:  
Sch'd to Ship:

68059  
Nov 04 2002

REPRINT  
Page: 1 Of 1

Sold To: Victoria Spring Ltd  
534 David Street  
Victoria  
British Columbia  
V8T 2C8

Ship To: Victoria Spring Ltd  
534 David Street  
Victoria

British Columbia V8T 2C8

## Packing List

Customer P.O.:	11334	Ship Via:	U.P.S.	Order Date:	Nov 01 2002
Quantity Ordered	Quantity Shipped	Product Description			
20	24	811-18-0400-01 Stainless Steel T302 Spring .0400 .040 dia x coil			
Gross:	25	Pieces:	1 coil		
Date Shipped:	11/4/02	Shipped with:			

All claims for shortages must be made within 10 days.  
Goods may not be returned without a Gibbs Authorization Number.  
The order will be billed at the price prevailing at the time of shipment.

## Material Certification

Heat No:	45101	Specification:	ASTMA313098						
C	Mn	P	S	Si	Cr	Ni	Mo	Co	Cu
.074	1.29	.022	.003	.63	18.80	8.40	.19		.21
Be	Fe	Al	Sn	Zn	Pb	Ag	V	N	Ti
								.03	
Tensile	291000 / 298000 PSI		Yield	/		Elongation	/		
Hardness	/ PSI		Grain	/		Cond Ch900	/		
Red of Area	0.00 / 0.00		Conductivity			Mill			

## Comments

Quality Department

We certify the above to be a true analysis of the material  
supplied on the above mentioned order.